H602GF5

START-UP RECOMMENDATIONS

<table>
<thead>
<tr>
<th>Nozzle</th>
<th>C1</th>
<th>C2</th>
<th>C3</th>
<th>C4</th>
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</thead>
<tbody>
<tr>
<td></td>
<td>380º F / 195º C</td>
<td>400º F / 205º C</td>
<td>420º F / 215º C</td>
<td>430º F / 220º C</td>
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<tr>
<td>410º F / 210º C</td>
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For hard to fill molds the temperatures may have to be increased. Keep lower temperatures in the rear zones to allow venting through hopper.

**Actual Processing Temperature Range**
Maximum temperature with a hand pyrometer should be 400º F to 470º F (204º C to 243º C).

**Mold Temperature**
Typically 110º to 130º F (43º C to 54º C). If mold temperature is too low the surface of the part will be rough and wavy.

**Injection Pressure**
The preferred range is 40 to 60% of machine capacity. Pressure should be sufficient to fill the mold without hesitation or flashing.

**Holding Pressure**
Setting should be lower than boost pressure with a minimum amount of time to prevent over-packing of the part.

**Injection speed**
Slow to medium speed to prevent excessive shear on the material.

**Cushion**
Maintain at 5 - 10mm to provide enough material for consistent parts.

**Decompression**
Use only when necessary to prevent nozzle drool.

**Screw RPM**
Screw should stop 1 to 2 seconds before mold open. A lower RPM is preferred for mixing and uniform melt temperature.

**Drying**
Material should be dried for a minimum of 2 hours and a maximum of 4 hours at 212º F (100º C).

**Note:** Barrel and hot runner needs to be thoroughly purged with a low MFR material.

**Disclaimer:** The user assumes all risk and liability concerning the use of these recommendations.